

## EUROPEAN PATENT OFFICE

## Patent Abstracts of Japan

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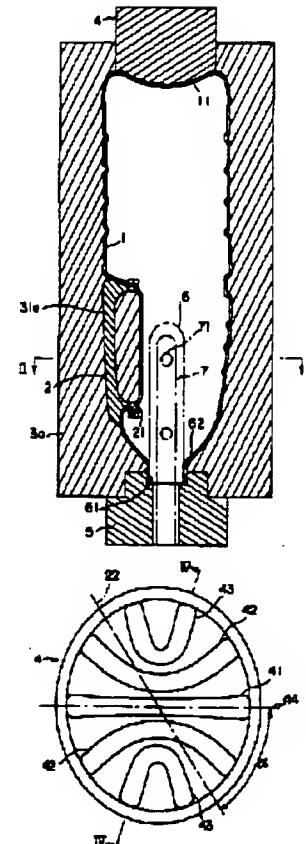
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**TITLE : MOLDING METHOD FOR BOTTLE  
WITH GRIP**



**ABSTRACT :** PURPOSE: To improve heat resistance of a bottom of a mold, to suppress a deformation and to suppress occurrence of an irregular thickness by correcting a deviation of a core of the bottom by setting a temperature of the body and the bottom of the molds to a predetermined temperature, inclining the bottom having an uneven shape at a symmetrical axis at a predetermined angle to a vertical plane including a center of a grip and a center axis of a bottle, and blow molding it.

**CONSTITUTION:** A preform 6 heated to 70-130°C in molds in which a grip 2 having an engaging part 21 is inserted is biaxially orientation blow-molded, a wall of the preform 6 is wound on the part 21 as a bottle with the grip. In this case, temperatures of the bodies 3a, 3b of the molds are set to 80-200°C, and a temperature of a bottom 4 is set to 50-150°C. The bottom 4 having uneven shapes 41, 42, 43 formed substantially linearly symmetrical with directional properties is so set as to be inclined at 20-70 degrees to a vertical plane 22 including a center of the grip and a central axis of the bottle. It is blow-molded in this state, brought into contact with the molds for several seconds to be heat treated, then cooled and removed.

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